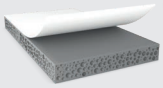
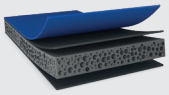
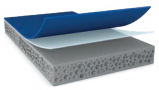
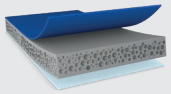
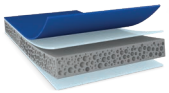
tesa AUTOMOTIVE

Acrylic Foam Tape Assortment (October 2019)

Product family		tesa® 772XX Base Line	tesa® ACX^{plus} 78XX Black Line	tesa® ACX^{plus} 771XX	tesa® ACX^{plus} 776XX	tesa® ACX^{plus} 777XX Primerless Line	tesa® ACX^{plus} 778XX Primerless Line[1]
Product design		 Single layer	 Single layer	 Three layers	 Two layers	 Two layers	 Three layers
Construction		Pure acrylic foam	Modified acrylic foam	Pure acrylic foam core with tackified acrylic adhesive	Pure acrylic foam core with covered side LSE adhesive	Pure acrylic foam core with open side LSE adhesive	Pure acrylic foam core with both sides LSE adhesive
Color		Gray	Deep black	Black	Gray	Gray	Gray
Thickness [mm]	0.5		tesa® 7805				
	0.8	tesa® 77208	tesa® 7808	tesa® 77108	tesa® 77608	tesa® 77708	tesa® 77808
	1.1		tesa® 7811		tesa® 77611	tesa® 77711	tesa® 77811
	1.2	tesa® 77212	tesa® 7812	tesa® 77112			
	1.5		tesa® 7815	tesa® 77115	tesa® 77615	tesa® 77715	tesa® 77815
Liner and tabbing		PV31 – white film liner • Thickness: 110 µm • Both sides siliconized • Tabbing solution: 54999 adhesive tabbing tape	PV29 – blue film liner • Thickness: 130 µm • Siliconized only on tape side Tabbing solution: 50999 heat tabbing film, 54999 adhesive tabbing PV25 – white paper liner • Thickness: 122 µm • Both sides siliconized	PV28 – blue film liner • Thickness: 160 µm • Silicone free film Tabbing solution: 50999 heat tabbing film, 54988 adhesive tabbing PV26 – white paper liner • Thickness: 160 µm Both sides siliconized	PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized	PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized	PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized Tabbing solution: 54999 adhesive tabbing
Special features		• Good initial adhesion on MSE[2] substrates • Good shear resistance at elevated temperatures	• High bonding power on MSE[2] substrates, outstanding on PC and PMMA • Excellent with primer on LSE[3] plastics especially on ribbed surfaces • Deep black color for invisible bond lines	• Excellent wet-out for high initial bonding power on MSE[2] substrates • Strong with primer on LSE[3] plastics especially on ribbed surfaces • Excellent shear resistance at elevated temperatures	• Excellent performance within the first minute of application on clear coats • Outstanding performance at an application temperature as low as 5 °C	• High initial adhesion to LSE[3] plastics • Full performance at an application temperature as low as 5 °C	• High initial adhesion to LSE[3] plastics and clear coats • Full performance at an application temperature as low as 5 °C
Adhesion after 72 h		tesa® 77212	tesa® 7812	tesa® 77112	tesa® 77611	tesa® 77711	tesa® 77811
	Steel	27 N/cm	32 N/cm	28 N/cm	Open side: 26 N/cm Liner side: 31 N/cm	Open side: 31 N/cm Liner side: 26 N/cm	35 N/cm
	ABS	12 N/cm	24 N/cm	26 N/cm	Open side: 12 N/cm Liner side: 28 N/cm	Open side: 28 N/cm Liner side: 12 N/cm	31 N/cm
	PP	37 N/cm[4]	90 N/cm[4]	73 N/cm[4]	37 N/cm[4]	Open side: 36 N/cm	38 N/cm
Temperature range		-40 to +80 °C	-40 to +80 °C	-40 to +90 °C	-40 to +80 °C	-40 to +80 °C	-40 to +80 °C
Static shear resistance at heat		90 °C > 10.000 min	90 °C > 10.000 min	100 °C > 10.000 min	90 °C > 10.000 min	90 °C > 10.000 min	90 °C > 10.000 min

Test methods:

Adhesion after 72 h:
Peel test in 90° angle
test speed: 300 mm/min

Static shear resistance
area: 25 mm x 25 mm
on steel, load: 200 g

1) 778XX roll with blue core, the rest products with white core
2) MSE: medium surface energy (38 - 50 mN/m)
3) LSE: low surface energy (29 - 37 mN/m)
4) Using tesa® 60153 primer